

Date: Friday, 19/12/2008 10:40:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 44196
 Estimate Number : 12615
 P.O. Number :
 This Issue : 19/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350578011
 Drawing Number : D2432 REV F3
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : F3
 Material :
 Previous Run : 41308 Due Date : 26/12/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JLD 08-12-19
 Comment : Est Rev:A New Issue 07-01-02 JLM
 Est Rev:B 08-01-09 Added Step 2 JLM Verified
 By:EC
 Est Rev:C 08-10-15 New Manufacturing Method JLM
 Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



For JLD 08/12/23



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8 09/01/09

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

JLD 08-12-19

3.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 3.4088 sf(s)/Unit Total : 34.0883 sf(s)

Material: Black UHMW 1"
 (MUHMWB10)

Batch: 108762 IB 8-12-22

4.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut Blank as per D2432 File

F3
 F3

IB 8-12-22

W/O:		WORK ORDER CHANGES					
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5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

M.A 08/12/31

(19)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/12/31

(19)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

22.500 08/12/31

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.5000 f(s)/Unit Total: 25.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B42737

Sil

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius-Block B42099

2 D2432F(ref only) Bearpaw 44196

9/1/9

Sil

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Seq. #:

Machine Or Operation:

Description :

11.0

D2438

Clamp



54



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

1330631

41428

50

12.0

D2529

Washer



108



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

1332028

1341431

50

13.0

AN417A

Bolt



108



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

1105653

100
1109061

50

14.0

AN960JD416

Washer



116



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

1109249

50

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -)

1108145

9/1/19

50

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Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5076109 (x9)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-578-011

Location: 11

Res A 9/1/12

SD

9x

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



mf 09-01-12

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DART AEROSPACE LTD		Work Order: 44196
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063	✓		
B	5.500	+/-0.030	5.501	✓		
C	0.200	+/-0.030	0.203	✓		
D	0.25 x 45°	+/-0.030	0.250 x 45°	✓		
E	R0.250	+/-0.030	R0.250	✓		
F	0.250	+/-0.010	0.252	✓		
G	0.625	+/-0.030	0.627	✓		
H	0.375	+/-0.010	0.380	✓		
I	0.950	+0.030/0.010	0.955	✓		
J	19.000	+/-0.030	19.000	✓		
K	3.14	+/-0.030	3.128	✓		
L	3.28	+/-0.030	3.295	✓		
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		
N	Ø0.93	+/-0.030	Ø0.927	✓		
O	0.30	+0.030/-0.000	0.305	✓		
P	23.750	+/-0.030	23.750	✓		
Q	7.375	+/-0.030	7.370	✓		
R	4.250	+/-0.010	4.252	✓		
S	2.000	+/-0.030	1.980	✓		
T	9.000	+/-0.010	8.996	✓		
U	9.000	+/-0.010	8.997	✓		
V	0.375	+/-0.010	0.375	✓		

Measured by: H.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/12/31	Date: 02-01-07	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF [Signature]

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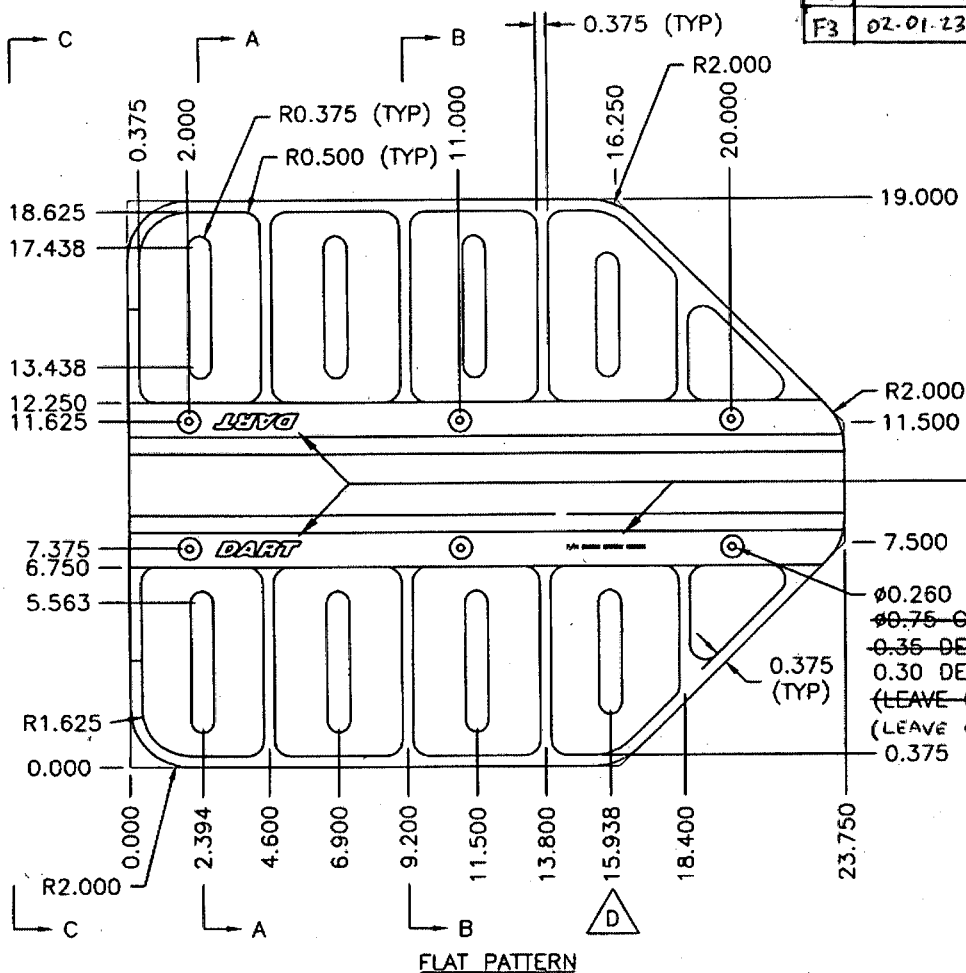
DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
MM	JS	D2432	SHEET 1 OF 2
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	

RELEASED
98.06.17 KE

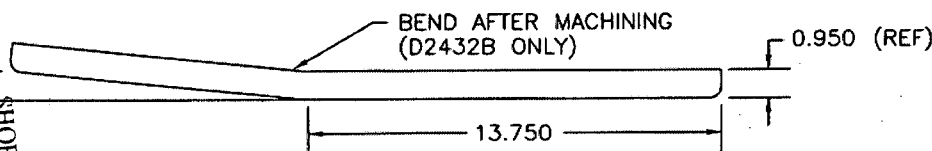
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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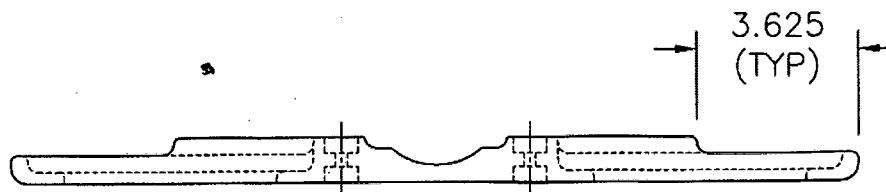
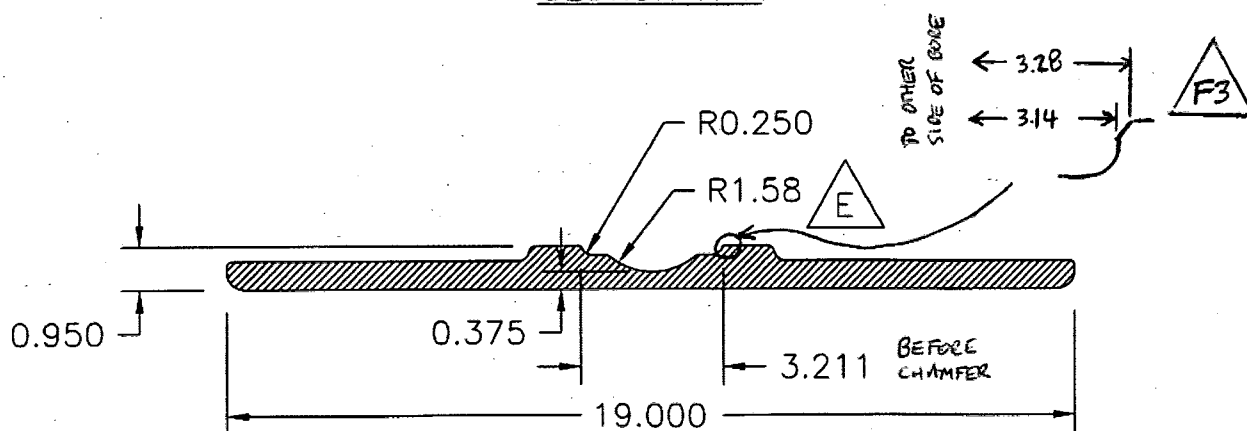
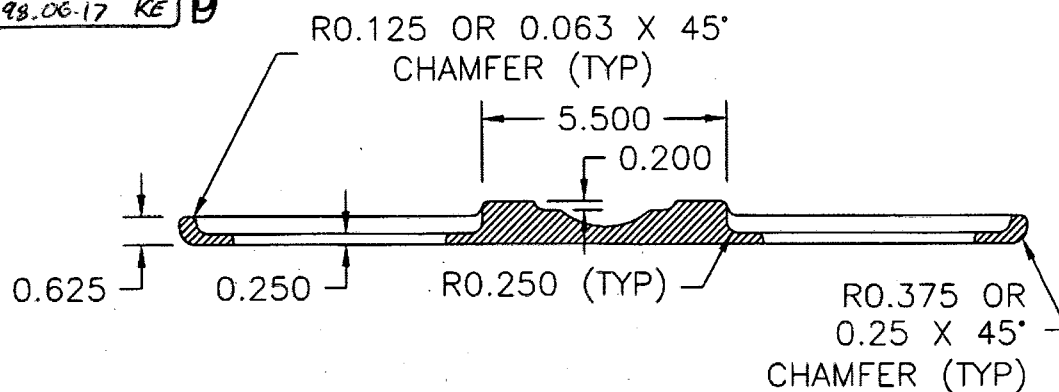
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44194